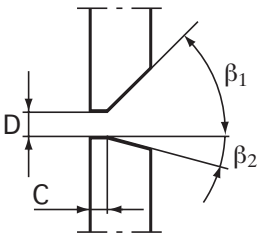
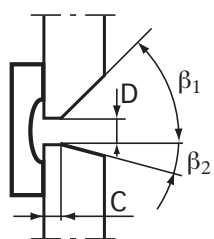
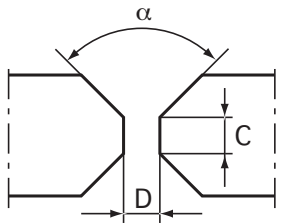
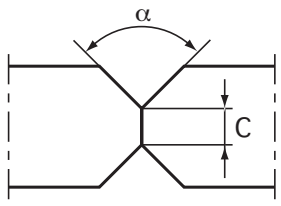


Joint preparations

Table 7.1

No. and joint type		Sides	Method	Thickness
12. V-joint $\beta_1 = 45^\circ$ $\beta_2 = 15^\circ$ $C = 1.0 - 2.0 \text{ mm}$ $D = 2.0 - 3.0 \text{ mm}$		One side	MMA FCW	4 – 16 mm
13. V-joint $\beta_1 = 45^\circ$ $\beta_2 = 15^\circ$ $C = 2.0 - 2.5 \text{ mm}$ $D = 2.0 - 2.5 \text{ mm}$		Two sides	MMA FCW	4 – 16 mm
14. V-joint $\beta_1 = 45^\circ$ $\beta_2 = 15^\circ$ $C = 1.5 - 2.5 \text{ mm}$ $D = 4.0 - 6.0 \text{ mm}$		One side against backing	FCW	4 – 20 mm
15. X-joint $\alpha = 60^\circ$ ³⁾ $C = 2.0 - 3.0 \text{ mm}$ $D = 2.0 - 2.5 \text{ mm}$		Two sides	MMA MIG TIG ⁶⁾ FCW	14 – 30 mm ⁸⁾
16. X-joint $\alpha = 80^\circ$ $C = 3.0 - 8.0 \text{ mm}$ ⁴⁾ No root gap		Two sides	SAW	14 – 30 mm

³⁾ The joint angle for special grades is $60 - 70^\circ$.

⁴⁾ A root land of 5 mm and above may require the torch to be angled towards the direction of travel, see "Width and depth" in chapter 4.

⁶⁾ Normally only for the first 1 – 3 runs. Followed by MIG, FCW, MMA or SAW.

⁸⁾ A thickness above 20 mm can be prepared as an asymmetrical X-joint.